



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

PC250-500
Job Sheet 200889



Part No: PC250-500

Job Qty: 3 pcs

Part Name: Lock



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/18/19

Job Tracking No:

Due Date: 10/31/19

Created By: Jennifer Renwick

Type: SOLD

Description: Order 19525

Note: DWG PC250-500 REV:1 IPP REV A 18.02.28 NEW ISSUE RQ VERIFIED BY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier	Sign-off
					Setup Hrs	Run Hrs		
120	HAAS 5 Axis	3 pcs	10/31/19	10/31/19	0.50	9.00	HAAS - 5	19-10-11
130	QC 2	3 pcs	10/31/19	10/31/19	0.00	0.00	QC 2 - 1	
							QC 2 - 12	
							QC 2 - 14	
							QC 2 - 17	
							QC 2 - 19	
							QC 2 - 2	19-10-11
							QC 2 - 20	
							QC 2 - 22	
							QC 2 - 23	
							QC 2 - 25	
							QC 2 - 32	
							QC 2 - 33	
							QC 2 - 35	
							QC 2 - 39	
							QC 2 - 4	
							QC 2 - 40	
							QC 2 - 44	
							QC 2 - 45	
							QC 2 - 48	
							QC 2 - 49	
							QC 2 - 50	
							QC 2 - 51	
							QC 2 - 52	
							QC 2 - 57	
							QC 2 - 62	
							QC 2 - 63	



Container No: S221883



Part: PC250-500

Job No: 200889

Serial No/Batch: S221883

Revision: 1

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL.: 1 613 632-5200
Email: sales@dartaero.com
www.dartaero.com

Date: 10/11/19

Plex 9/18/19 1:23 PM Dart.Renwick.Jennifer

					QC 2 - 8	
					QC 2 - 66	
					QC 2 - 64	
					QC 2 - 65	
					QC 2 - 5	
					QC 2 - 71	
					QC 2 - 73	
					QC 2 - 69	
					QC 8 - 12	
					QC 8 - 14	
140 QC 8	3 pcs	10/31/19	0.00 0.00		QC 8 - 17	
					QC 8 - 20	
					QC 8 - 25	
					QC 8 - 3	
					QC 8 - 32	
					QC 8 - 33	
					QC 8 - 35	
					QC 8 - 39	
					QC 8 - 4	
					QC 8 - 44	
					QC 8 - 45	
					QC 8 - 49	
					QC 8 - 58	
					QC 8 - 8	
					QC 8 - 9	
					QC 8 - 68	
					QC 8 - 67	
					QC 8 - 1 (A)	
					QC 8 - 47	
					QC 8 - 40	
					QC 8 - 52	
					QC 8 - 23	
					QC 8 - 57	
					QC 8 - 76	
					MEI001-VC	
					Packaging 2 - 1 - B4B	
					Packaging 2 - 2 - B4B	
					Packaging 2 - 3 - B4B	
					Packaging 2 - 5 - B4B	
					Packaging 2 - 4 - B4B	
					Packaging 2 - 6 - B4B	
					Packaging 2 - 7 - B4B	
					Packaging 2 - 8 - B4B	
					Packaging 2 - 9 - B4B	
					Packaging 2 - 10 - B4B	
					Packaging 2 - 11 - B4B	
					Packaging 2 - 12 - B4B	
					Packaging 2 - 13 - B4B	
					Packaging 2 - 14 - B4B	
					Packaging 2 - 15 - B4B	
					Packaging 2 - 16 - B4B	
					Packaging 2 - 17 - B4B	
					Packaging 2 - 18 - B4B	
					Packaging 2 - 19 - B4B	
150 Outsource - 1 - Heat Treat	3 pcs	10/31/19				
160 Packaging 2-1 - Receive - B4B	3 pcs	10/31/19	0.00 0.00			

m 19/10/18

2019-10-22

DP NOV 01 2019

				Packaging 2 - 20 - B4B	
				Packaging 2 - 21 - B4B	
				Packaging 2 - 22 - B4B	
				Packaging 2 - 23 - B4B	
				Packaging 2 - 24 - B4B	
				Packaging 2 - 25 - B4B	
				Packaging 2 - 26 - B4B	
				Packaging 2 - 27 - B4B	
				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
170 QC 6	3 pcs	10/31/19	0.00 0.00	QC 6 - 9	
				QC 6 - 68	
				QC 6 - 61	
				QC 6 - 40	
				QC 6 - 81	
180 Packaging 3-1 - Stock - B4B	3 pcs	10/31/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

DAS

NOV 01 2019 68

9-89

MLK

					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
190 QC 21 - SA	3 pcs	10/31/19	0.00	0.00	QC 21 - SA - 21	
					QC 21 - SA - 70	
					QC 21 - SA - 53	

NOV 08 2019

CA
209

Part Op 120 - (HAAS CNC vertical machine #5) 1-Machine as per folio FB980 FOLIO REV: AA DWG REV:
 Descriptions: 1 2-Machine engrave Batch# S221883 3-Deburr 4-Apply LPS-3 to ALL steel parts

130 - (QC2- Inspect parts off machine FAI/FAIB)

140 - (QC8- Inspect parts - second check)

150 - 1-Issue P/O; 44848 Heat treat RC 42-44 2-Bead blast 3-Apply LPS-3 rust inhibitor 4-Material type; O1 5-
 Certificate of Conformity is required

160 - (Pac2-Receive & Inspect for Damage & Mat'l Certs.)

170 - (QC6- All purchased or subcontracted products)

180 - (Identify as per dwg & Stock Location: _____) Identify and Stock

190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-4140-B-2.250X3.000	AISI 4140 Steel Bar, 2.50" Thick X 3.00" Wide	1.8750 ft (.625 ea)	120-HAAS 5 Axis	<u>5077 656</u>
<u>MT-4140-S-2.250X3.000</u>		<u>1.833' / .611 each</u>		

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
120-HAAS 5 Axis	MT-4140-B-2.250X3.000	2	0	0

Part Specifications

Specifications could not be found.

Plex 9/18/19 1:23 PM Dart.Renwick.Jennifer



Entered: _____ Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only

NCR No. _____

Job: _____

Part No. _____

DISPOSITION

Rework ☐
Scrap ☐
Use-as-is ☐

DEPARTMENT/PROCESS

Skid-tube ☐
Machining ☐
Large Fab ☐

Cross tube ☐
Small Fab ☐
Finishing ☐

Eng. (Non-AW) ☐
Prod. Eng. Coord. ☐
Rec/Store/Packaging ☐

Engineering ☐
Water Jet ☐
Supplier ☐
Quality ☐

Date: _____

Sequence #: _____

QTY Affected: _____

MRB (QS1042)

Description Work Order Deviation

Disposition

Completed By _____

Lead hand / Supervisor _____

QC / QA Coordinator _____

Root Cause

Operator ☐
Manufacturing Process ☐
Equip/Tooling ☐
Handling/Preservation ☐
Material ☐
Product Improvement ☐
Process Improvement ☐
Human Factors ☐

FAULT CATEGORY

Pressure/Forced ☐
Bending ☐
Crushing ☐
Cracks ☐
Crimp/Kink/Ripple/Wave/Twist ☐
Marks/Chatter ☐
Mislabeled ☐
Contamination ☐
Misaligned/off center ☐
BOM/Route ☐
Broken/Damage/Defect ☐
Incomplete/Unclear Instructions ☐
Drill Holes ☐
Fit/Function ☐

Power Loss/Surge ☐
Folio/Program ☐
Grain Direction ☐
Weld ☐
Wrong Stock Pulled ☐
Out of Sequence ☐
Off-set/Set-up ☐

Positioned Wrong ☐
Outside Tolerance ☐
Drawing ☐
Finish ☐
Part Lost/Missing ☐
Misread ☐

Other/Details: _____

DART AEROSPACE LTD		Work Order: 200 889
Description: LOCK		Part Number: PC250-500
Inspection Dwg: PC250-500A	Rev: 1	Page 1 of 1

INSPECTION SHEET

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.107	+/- .005	1.107	✓		Height gauge	
101°	+/- .5°	101°	✓		Protractor	
.625	+/- .005	.626	✓		SLO2	Mic
.250	+/- .005	.252	✓		"	
.125	+/- .005	.125	✓		"	
.688	+/- .005	.688	✓		SL10	VERN
7.033	+/- .005	7.0325	✓		Height gauge	
.500	+/- .005	.501	✓		SLO2	Mic
1.000	+/- .005	.999	✓		SL10	VERN
2.000	+/- .005	2.003	✓		SLO3	Mic
.02 X 45°	+/- .010	.020	✓		SL10	VERN
R.06	+/- .010	.060	✓		Rod gauge	
.75	+/- .010	.750	✓		Height gauge	
Ø.094	+ .004 / - .001	.094	✓		gauge Pin	
3.26	+/- .010	3.260	✓		Height gauge	
Ø2.37	+/- .010	2.375	✓		SL10	VERN
1.875	+/- .005	1.875	✓		"	
Ø.630	+ .002 / - .001	.630	✓		SLO2	Mic
Ø.793	+ .0005 / - .000	.793	✓		"	
.04 X 45°	+/- .010	.043	✓		SL10	VERN
R.08	+/- .010	.080	✓		Rod gauge	
R4.47	+/- .010	4.470	✓			
R.02	+/- .010	.020	✓			
R.29	+/- .010	.290	✓			
R5.16	+/- .010	5.160	✓			
R.02	+/- .010	.020	✓			
R.33	+/- .010	.330	✓			
R.09	+/- .010	.090	✓			
R.38	+/- .010	.380	✓			
R.69	+/- .010	.690	✓			
R.33	+/- .010	.330	✓			
R.50	+/- DAS .010.	.500	✓			

Measured by: 20 9-89	Checked by: <i>Amf</i>	QC Inspector:
Date: 19-10-09	Date: 19/10/18	Date:

Engineering Approval: (If necessary)	Date:
--	--------------

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER **POHB044848**



Supplier: MEI001-VC
Metcor Inc.
560 Boul. Arthur Sauve
Saint-Eustache
QC
J7R 5A8 Canada
Phone: 450 473 1884
Fax: 450 491 5498

Attention: Bejenaru, Livia

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

PO No: POHB044848

PO Date: 10/22/19

Due Date: 11/7/19

Purchase Order

Revision:

Revision Date:

Ship-To Contact: Guerin, Kimberley
Phone: 613-632-5200 Ext: 298
kguerin@dartaero.com

Via: Ground

Pymt Terms: Net 30

Freight Terms:

Special Comments:

E-MAILED
2019-10-23

Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	201481	RBE117-12020W16-1	RBE117-12020W16 Rev B	Frame 1-Issue P/O; RC 40-45 2-Bead blast 3-Material type; 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/7/19	6 pcs	0 pcs	6 pcs	\$52.3333/pcs	\$314.00
2	200889	PC250-500	PC250-500A Rev 1	Lock 1-Issue P/O; Heat treat RC 42-44 2-Bead blast 3-Apply LPS-3 rust inhibitor 4-Material type; O1 5-Certificate of Conformity is required	Firmed	-	11/7/19	3 pcs	0 pcs	3 pcs	\$104.6666/pcs	\$314.00



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K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB044848



Items

Line Item	Job	Part	Drawing	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
3	201267	RB T102137-111-103	RB T102137-111 Rev B	Strap (Outsource process - Heat Treat) 1-Issue P/O; Heat treat RC 32-38 2-Bead blast 3-Material type; 4140 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/7/19	8 pcs	0 pcs	8 pcs	\$39.25/pcs	\$314.00
4	201988	20NR-84B	20NR-84B Rev 2	Spacer Dual Cage 4, 5/8" hole 1-Issue P/O; RC 33-37 2-Bead blast 3-Material type; 1045 4-Apply LPS-3 to ALL steel parts 5-Certificate of Conformity is required	Firmed	-	11/7/19	6 pcs	0 pcs	6 pcs	\$52.3333/pcs	\$314.00
Grand Total:											\$1,256.00	

Order Notes

Procurement Quality Clauses
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retension of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Plex 10/24/19 10:02 AM Dart.Guerin.Kimberley

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ
ST-EUSTACHE, QC J7R 5A8
Tel: 450-473-1884 / Fax: 450-491-5498

Reçu de livraison

Delivery Receipt

BON DE TRAVAIL Order	EXPÉDITEUR Shipper ID	BON D'EXPÉDITION Shipper
340243	1	141122

EXPÉDITION COMPLÈTE / Shipped Complete

CLIENT /Customer 215

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053



LIVRÉ À /Shipped To

DART AEROSPACE
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
Ph: 613-632-5200
Fax: 613-632-1053

COMMANDE DU CLIENT Customer PO	BON DE LIVRAISON DU CLIENT Customer Shipper No.	TYPE DE MATÉRIEL Material Type	DATE DE LA COMMANDE Order Date	TRANSPORTEUR Carrier
HB044848		O1	2019/10/23	CLIENT
QUANTITÉ Quantity	No. PIÈCE / Part No.	NOM DE LA PIÈCE / Part Name	DESCRIPTION DE LA PIÈCE Part Description	POIDS Weight

3 PC250-500

(3) PC250-500

JOB 200889

10,

1 BC EPS

TYPE DE CONTENEUR Container Type	# DE CONTENEURS # Of Containers	COMMENTAIRES CONTENEUR Container Comments
BC EPS	1	

EXPÉDIÉ PAR: Shipped by:	
------------------------------------	--

QUANTITÉ EXPÉDIÉE / Quantity Shipped : 3

POIDS EXPÉDIÉ / Weight Shipped : 10,00

QUANTITÉ RESTANTE / Quantity Remaining : 0

POIDS RESTANT / Weight Remaining : 0,00

RECEIVED

NOV 01 2019

DART AEROSPACE LTD. **APPROUVÉ**

QUANTITÉ EXPÉDIÉE /Quantity Shipped:	3
POIDS EXPÉDIÉ / Weight Shipped :	10,00

Signature:

Date:

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
340243	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB044848	N/A	O1		

SPÉCIFICATIONS DU PROCÉDÉ processing specifications

SEL HARDEN

HARDEN AND TEMPER

EXIGENCE / requirement	SPÉCIFICATIONS / specified	TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	42 - 44 HRC	3 (907)	42 - 43 HRC DAS 68 9-89

QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description
3	10	PC250-500 (3) PC250-500 JOB 200889 1 BC EPS

8 Nov

COMMENTAIRES / comments

APPROUVÉ par / Approved by:

Alexandre Demuyt

MET
71

DATE: 2019-10-29

APPROUVÉ
[Signature]

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
340243	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

1

COMMANDE DU CLIENT customer po	CLASSIFICATION PIECE part classification	MATÉRIEL material	MAÎTRE D'OEUVRE prime contractor	PROGRAM
HB044848	N/A	O1		
SPÉCIFICATIONS DU PROCÉDÉ processing specifications				
SEL HARDEN				
HARDEN AND TEMPER				
EXIGENCE / requirement	SPÉCIFICATIONS / specified		TESTS EXÉCUTÉS / performed	RÉSULTATS DE TESTS / results
HARDNESS	42 - 44 HRC		3 (907)	42 - 43 HRC
QUANTITÉ quantity	POIDS weight	DESCRIPTION DES PIÈCES parts description		
3	10	PC250-500 (3) PC250-500 JOB 200889 1 BC EPS		

DAS
68
9-89

DAS
68
9-89

COMMENTAIRES / comments

SALT HARDEN 1475°F - 50 MINS

SNAP TEMPER 400°F - 2:00 HRS

TEMPER 900°F - 3:00 HRS

BEAD BLAST

OIL

Heat treatment (HT) was performed with equipment that meets the requirements of requested specification. All HT operations were performed in compliance with the required HT specification and all verifications have been performed and documented. No unauthorized changes were performed in regards to the HT. We certify that the material was manufactured, sampled, tested and inspected in accordance with the material specification and the purchase order and was found to meet the requirements.

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Le traitement thermique (TT) a été fait en utilisant des équipements en conformité avec la spécification demandée. Toutes les opérations de TT ont été faites en conformité avec les requis de la spécification demandée et toutes les

METCOR INC.

560 BOUL. ARTHUR-SAUVÉ, ST-EUSTACHE, QC, J7R 5A8

Tél.: 450-473-1884

Télécopieur / Fax administration: 450-491-5498

Télécopieur / Fax production: 450 491-6454

Certificat de Conformité Détaillé

Detailed Certificate of Compliance

BON DE TRAVAIL order	CHARGEMENT load
340243	1

CLIENT / customer 215

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

LIVRÉ À / shipped to:

1

DART AEROSPACE

1270 ABERDEEN

HAWKESBURY

ON K6A 1K7

vérifications et les tests demandés ont été faites et documentés. Aucun changement n'a été faite par rapport au TT. On certifie que le matériel a été fabriqué, échantillonné, testé et inspecté en accord avec les spécifications du matériel et le bon de commande et le matériel rencontre les exigences spécifiées.

Ce document et les documents qui lui sont joints peuvent contenir des informations confidentielles, être soumis aux réglementations relatives au contrôle des exportations ou ayant un caractère privé. S'ils ne vous sont pas destinés, nous vous signalons qu'il est strictement interdit de les divulguer, de les reproduire ou d'en utiliser de quelque manière que ce soit le contenu. Toute exportation ou réexportation non autorisée est interdite.

APPROUVÉ par / Approved by:

DATE: 2019-10-31

Lucie Desmarais
QA Technician

